Dart Aerospace Ltd.

Date: Tuesday, 29/04/2008 10:47:27 AM
User: Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: TUBE
Job Number	: 38880		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D37691
This Issue	: 29/04/2008 S.O. No. :	Drawing Number	: PROTOTYPE
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : R & D SM/MED FAB	Drawing Revision	: A
Previous Run	: 38866	Material	:
Written By	:	Due Date	: 16/05/2008 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product PROTOTYPE

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 MAKE PER DRWG D3769 REV A	ml 08/05/07 x2
2.0	M6061T6T1000W065	6061T6 TUBE
	Comment: Qty.: 1.2600 f(s)/Unit Total : 2.5200 f(s) 6061T6 TUBE	2 x 104.450 M 18639 x1 M 18188 x1 ~~M [illegible] x1~~ ml 08/05/07
3.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	ENGINEERING APPROVAL 08.05.07 02/05/07
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 ACID ETCH AND ALODINE PER QSI 005	05/05/12 (2)
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	5/5/12 (2)

Form: rprocess

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Process Sheet

[redacted]stomer: CC-DAR01 Dart Aerospace Ltd. **Drawing Name:** TUBE

Job Number: 38880 **Part Number:** D37691

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

GIVE TO CHRIS P-ENG

CHARGE TO JOB #00196

FOR ENGINEERING USE ONLY

01.05.29

7.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

08.05.29 Prototype

Job Completion

58.06.11

Form: rprocess

Receiving Report

Date: 05/09/27
Supplier: Acier Campi

Batch No: 18639
Dart P/O: 2008702

Packing Slip: Yes ✓ No ___
Invoice: Yes ___ No ✓
Receipt: Cash ___ Cr. ___

Release Note Attached: Yes ✓ No ___ N/A ___
Waybill Attached: Yes ___ No ✓
Shipment Complete: Yes ___ No ✓
Q.C. Inspection ___

Discrepancies

Part No.	Desription	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6061T6S.125		96	0		96	

TSR No. ___

Initials of receiver (if shipment OK) DL

Production/Admin:
Date Received/Costing 05/09/27 2008702
Initial ___
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Accounting:
Date ___
AP/MR ___
Initial ___

M6061T6T1.500W.125 6061T6 TUBE 1.500X .125W 09-27-5 2.6000 /f 156.00

MATERIAL: 6061-T6 OR 6061-T62 TUBING PER
WW-T-700/6 OR AMS4080 OR AMS4082 OR
QQ-A-200/8 OR QQ-A-225/8

Total Value of Purchase Order $1,083.60

Aug 09 23

SAMPLE (S) OF ALUMINUM

REPORT: 38548

DIE NO.	H-2367
DESCRIPTION	1" O.D.X0.060" TUBE
AL. ALLOY & TEMPER	6061/T6
EXTRUDEX ORDER NO.	73632-5-A.11
SPECIFICATION	ASTM B221 cp note 05-05-19 THIS BATCH ONLY
SILICON %	0.54
IRON %	0.17
COPPER %	0.18
MANGANESE %	<0.01
MAGNESIUM %	0.80
CHROMIUM %	0.07
ZINC %	<0.01
TITANIUM %	<0.01
ALUMINUM %	REMAINDER
ALLOY TYPE %	6061
ALLOY CAST NO.	05072822A
YIELD STREGTH (IN ksi)	37.1
TENSILE STREGTH (IN ksi)	42.4
ELONGATION % IN 2"	11.0
HARDNESS (ROCKWELL 'F')	87.9 87.1 87.6

N.RAMPERTAB
(LAB TECH)

DATE: JULY-18-05

Receiving Report

Date: 05/08/02
Supplier: Mormon / Keystone

Batch No: M18168
Dart P/O: 200830C

Packing Slip: Yes ✓ No ___
Invoice: Yes ___ No ✓
Receipt: Cash ___ Cr. ___

Release Note Attached: Yes ✓ No ___
Waybill Attached: Yes ✓ No ___
Shipment Complete: Yes ___ No ✓
Q.C. Inspection ___

Discrepancies

Part No.	Desription	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M606(T6)T1.750 W.065		300	228		72	

TSR No. ___

Initials of receiver (if shipment OK) ___

Production/Admin:
Date 05-08-05
Received/Costing 2-8300
Initial ___

Accounting:
Date ___
AP/MR ___
Initial ___

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216/FT
228
Dr.
05/08/02

ATS 1.750 .065 D6061
HT#.....: 1461978

18	216/FT
18	216/FT

Total...

No. of Bdls/Pieces 4/ 1

Total Weight.....: 202

Customers.: ___

From: MARMON/KEYSTONE To:

INIT.: OR.REF:

1278GD SLSPRS:

KAISER CHANDLER

CHANDLER PLANT
BOX 5011 6573 W WILLIS ROAD
CHANDLER AZ 85226
PH: 520.796.1097
FAX: 520.796.0596
SALES: 800.528.8274

CERTIFICATION and PHYSICAL TEST RESULTS

QP 026A

These results are for **MARMON/KEYSTONE CORP**

Mill Number ..... **175-42921.** Purchase Order No **60-17566-005**

Alloy ..... **6061** Temper..... **T6**

Part No, Item No, Commodity No or Inventory No

Size Description. **1.00 IN OD X .065 IN WALL**

Specification(s). **WW-T-700/6F ASTM B210-04 AMS 4082N**

Additional procedures as called for on Specification:

MADE IN U.S.A. WE TAKE EXCEPTION TO PARA. 5.2.1. Per AMS 4082N, WAS NOT OILED.

Limits	*Chemical Composition*				*Per Aluminum Standards and Data 2003*						
MIN	0.40	*	0.15	---	0.8	0.04		—	—	Ea 0.05	Remainder
MAX	0.8	0.7	0.40	0.15	1.2	0.35	—	0.25	0.15	Total 0.15	
Actuals	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others	Al
	0.64	0.25	0.21	0.03	0.93	0.07		0.02	0.02		
	0.61	0.32	0.23	0.02	0.95	0.06		0.05	0.02	Each 0.05	Remainder
										Total 0.15	

** For WW-T-700/4 specification, maximum Si plus Fe is .45%.* *** 1100 Alloy Max Si + Fe is 0.95 %*

Mechanical Properties				
Lot #	*\ Temp*	*Yield PSI*	*Ultimate PSI*	*Elongation %*
42921	D\ T6	42,900	47,100	14

Q. C. REVIEWED

We hereby certify that the material covered by this report has been inspected in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description; and that samples representative of the material met the composition limits and had the mechanical properties as indicated.

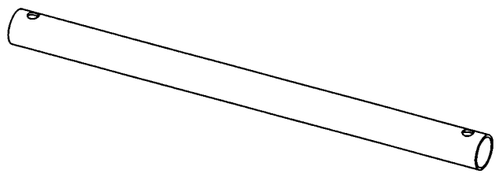
Date 05/25/2005 C E Brooks

C. E. BROOKS
Tech. Mgr. Tube

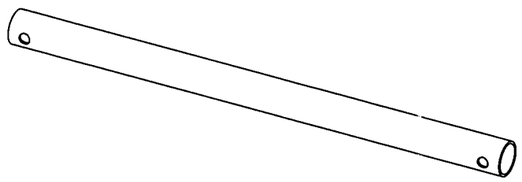
CertAct

form:CertAct

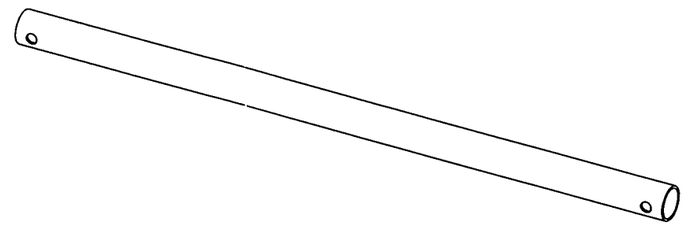
AT 11.065 734



D3769-1 TUBE



D3769-3 TUBE



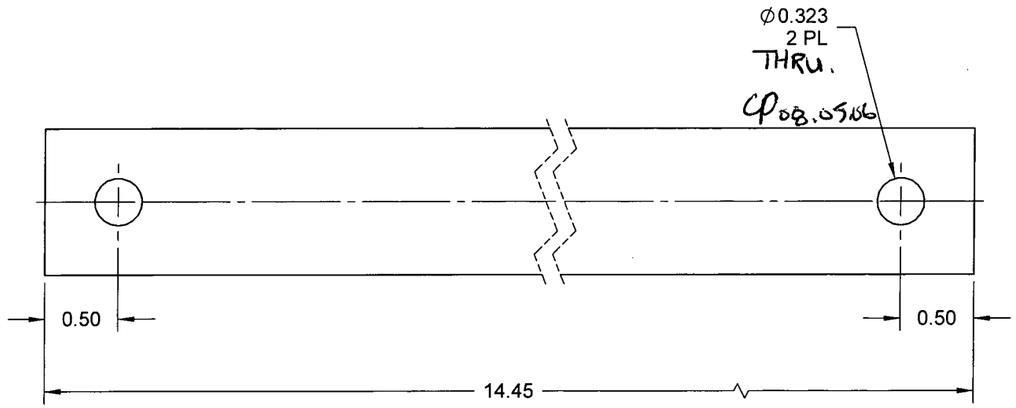
D3769-5 TUBE

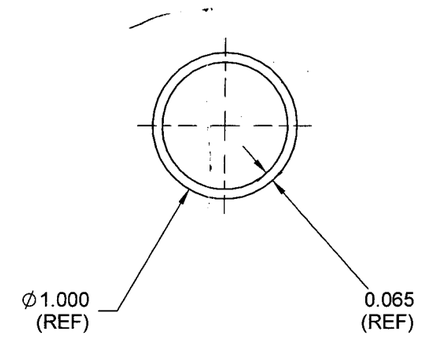
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.04.22

NOTES:
1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM TUBING 1.00" X 0.065" WALL (REF. DART SPEC. M6061T6T1.000W.065)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3769-1, 0.27 lbs
D3769-3, 0.28 lbs
D3769-5, 0.37 lbs

REV.	DESCRIPTION	BY	DATE

DESIGN	HS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO. D3769	REV. A
MFG. APPR.			SHEET 1 OF 4
APPROVED		TITLE TUBE	SCALE NTS
DE APPR.			
DATE	08.03.26		





D3769-1 TUBE

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
CP 08.04.23

DESIGN	HS	**DART AEROSPACE LTD**	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3769	REV. A
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE TUBE	SCALE 1:1
DE APPR.			
DATE 08.03.26			